

Date: Wednesday, 7/11/2007 2:46:17 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING		
Job Number	: 33468		Part Number	: D2570		
Estimate Number	: 10175		Drawing Number	: D2570 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 7/11/2007	S.O. No. : N/A	Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 7/31/2007		
Previous Run	: 32103		Qty:	500	Um:	Each
Written By	: J					
Checked & Approved By	: 07/07/07					
Comment	: Est E 02.08.29 Re-format; Removed finishing; Material change K J est F 07.07.06 rev B dwg EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M303R0750	303 Round Bar .75"
		
Comment: Qty.: 0.0810 f(s)/Unit Total : 40.4775 f(s) Material: Ø0.750 AISI 303 SS Rod (M303R0.750) Batch 105145 <i>07/20 07/08/08</i>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		
Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA198 Deburr and tumble <i>07/20 07/08/08 600 DSP 07/08/08</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
<i>07/20 07/08/08 600 DSP 07/08/08</i>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
		
<i>07/20 07/08/08 600 DSP 07/08/08</i>		
Comment: SECOND CHECK		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>07/08/10 (500)</i>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: AD Date: 07/08/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 33468

Part Number: D2570

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



500

D7/08/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



207/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33468
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570	Rev: A B 01 03.07.11	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

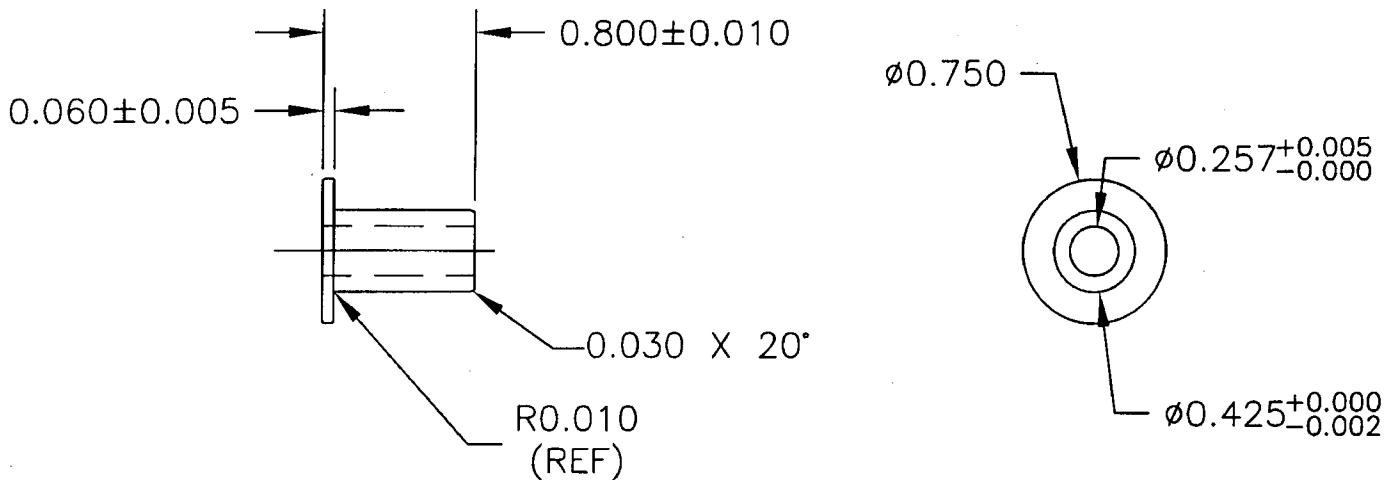
Measured by: <u>RP/J.S.</u>	Audited by: <u>SA</u>	Prototype Approval: N/A
Date: <u>07/08/08</u>	Date: <u>07.08.08</u>	Date:

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	

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**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2570	REV. B	SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE	1:1
A	96.09.16	NEW ISSUE		
B	07.04.17	UPDATE NOTES		

**RELEASED**  
07.06.28 *PH***D2570 BUSHING****D2570 BUSHING**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *33468*

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